Work Orde Øctober-29-13 1	r ID 108837 0:09:09 AM			*108	8837*	•					Page 1
Revision ID:	D3595-063-450	g mine dedition	en al al anno al estado en al anterior de la composição d	Accept	*N9(1004 0	1100)* s	etup Start Stop	I VI.	S1*
·		t Qty: 30.00 d Qty: 30.00	*20* *30*	138¥	Cust I	tem ID: mer:			эцф	*N:	S2*
Approvals:	Process Plan:	ルブ	Date: 13-10-30	Tooling:		Date:		R	un Start	*N	R1*
	QC:		Date:	SPC (Y/N):		Date:			Stop	*N!	R2*
Sequence ID/ Work Center ID	Oper Desci	ation ription		Set Up/ Run Hours	Tool	ID Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision N	Nbr									
D3595	Rev A										
*100 *100*	FLOW	WATER JET		0.00				38	J		A
Waterjet FLOW CNC Waterje	t	Memo 1-Cut as pe Deburr if no	r Dwg D3595 Dwg Rev:_ ecessary	0.00 Prog Rev:	2-						14.01.0
110	QC2-	Inspect parts off r	nachine FAI/FAIB	0.00							
110 QC Quality Control		Memo		0.00				38	O		14.01.
120	QC8-	Inspect parts - sec	ond check	0.00 27				21			
120 OC Quality Control		Memo		0.00 1411	1			Count	# ******* #.		

	. Date:										TOME
	_			WORK ORDER NON-	-CC	ONFO	RMANCE / UP			_	AEROSPACE
	Date:								Work Order	update only	
er:				DISPOSITION							
				Rework			Skid-tube	Crosstube		Water let	Engineering
lo.						:	 	-	→ P	<u> </u>	Quality
				Use-as-is			~ 	<u>-</u>	_		Other
lo				Suspected Unapproved			Large Fab	Composite		· · · · · · · · · · · · · · · · · · ·	-
					•						
			Desci	ription of work order update	1	nitial	Actio	on	Sign &		
Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC Inspector
_										ľ	
_											
	1	<u> </u>					<u> </u>				
					FAI	ULT CA	TEGORY				
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			-		_	1	rogram			⊢	Pressure/Forced
	ot Concer	ntric	\vdash	·		1			⊣	}	Set-up
	ali (Dianala	// // -	-	-	_	i				<u> </u>	Temperature/Cure
	тк/кірріе	ywave	\vdash		_	i '	,	` -			Weld
			-			1		nclear		<u> </u>	Wrong Stock Pulled
	.+				_	•		-	_	_	¬
		Tubo	-		\vdash	ł		Ĺ	Power Los	s/Surge	Other
		Tube	-		_	ł					
			_		\vdash	i					
— — — — — — — — — — — — — — — — — — —			-	1							
	Date Date Date Gear Bending Centre No Cracks Crimp/Kin Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	Date: Da	Date: Da	Date: Date: Date: Date Step Qty Description Descript	WORK ORDER NON- Date: DISPOSITION Rework Scrap Use-as-is Suspected Unapproved Date Step Qty Description of work order update or non-conformance Date Step Qty General Bend Sending Sending Sending Sending Sending Centre Not Concentric Cracks Broken/Damage/Defect Burrs Cuffs Contamination Countersink Cut Too Short Inspection Strip in Tube Marks/Chatter Turning Sequence Trurning Sequence Finish	WORK ORDER NON-CO Date: DISPOSITION	WORK ORDER NON-CONFO	WORK ORDER NON-CONFORMANCE / UP Date: DISPOSITION Rework Scrap Wachining Thermoforming Large Fab Large Fab Date Step Qty Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description of work order update or non-conformance Chief Eng Description Description of work order update or non-conformance Chief Eng Description Description Office Eng Description Description Office Eng Description Description Office Eng Description Office E	Date Date Description Description Description Description Description Description Date Step Qty Description of work order update Or non-conformance Description Date Step Qty Description of work order update Chief Eng Description Description	Date Date Disposition Date Date	Date Disposition Rework Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Suspected Unapproved Large Fab Composite Suspected Unapproved Composite Sign & Composite Part Lost/Missing Date Step Qty Or non-conformance Chief Eng Description Date Verification Date Verification Date Power Lost/Nissing Part Lost/Missing Part Lo

Work Order ID 108837

OC:

Page 2

October-29-13 10:09:09 AM Item ID: D3595-063-450 Revision ID: Rubber Cushion Itëm Name: Start Date: 10/29/13 Req'd Qty: 30.00 Reduired Date: 10/29/13

Accept

N900040100

Setup Start

Start Oty: 30.00

30 *30*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Stop

Sequence ID/ Work Center ID Operation **Description** Set Up/ **Run Hours** Tool ID Tool # Plan

Code Qty

Accept Reject Qty

Run

Reject Number

Insp. Stamp

130 *130*

Packaging Packaging

Memo

Identify as per dwg & Stock Location:

0.00

QC21- Final Inspection - Work Order Release

0.00

1//0

* QC

Memo

0.00

14-01-13 De 08/01/14 N/4-01-8

Quality Control

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE									DART
QA Closed:			Date:					J. 11 O.			Wo	ork Order up	date only		AEROSPACE
Work Orde						DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
WOIK OIGE						Rework			Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	10.					Scrap			Machining	Small Fab		Prod. Eng. Coor.			Quality
	_					Use-as-is		Thern	noforming	Finishing		1	re/Packaging		Other
NCR N	10					Suspected Unapproved		· -		Composite[-	Supplier			
Root					Desci	ription of work order update		nitial	Ac	tion	·	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification		QC Inspector
Design															
Doc/Data															
Equip/Tooling	\Box												i		
Handling/Pre	\Box														
Material	_									•					
Operator Properties of the Control o	_														
Offset/Setup	_														
Process	_						İ								•
Supplier	\Box						İ								
Training	_		į												
Transport															
Unapproved	\perp		<u> </u>				<u> </u>								
				•			FA	ULT CAT	regory		•				
Landi	$\overline{}$					General	_	1		ı		1	г	- 1	
	-	Bending	_			Bend	<u> </u>	1	Program			Outside Dim	}		Pressure/Forced
	\vdash	Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain				Over/Under	F		Set-up
	_	Cracks			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		_		Part Incorre			Temperature/Cure
	\vdash	Crimp/Kir	ık/Ripple	/Wave	.	Burrs	<u> </u>	1	ion Incomplete/U	· .		Part Lost/Mi	ssing		Weld
	$\overline{}$	Cuffs .			_	Contamination	<u> </u>	ł	ions Incomplete/	Unclear		Part Moved	Į.		Wrong Stock Pulled
	_	Crushing				Countersink	<u></u>	4 -	ned/off center			Positioned V			İ
	Н	Heat Trea			<i>*</i>	Cut Too Short	<u></u>	Mislabe			L	Power Loss/	Surge [Other
	\boldsymbol{H}	Inspection		Tube	<u> </u>	Drawing	<u> </u>	Misread							
	-	Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set							
	-	Turning S	•		_	Finish	<u> </u>	4	Calibration						
	[]	Wave/Tw	ist in Tub	oe -		Fit/Function	1	Out of 9	Sequence						

October-29-13 10:09:09 AM

Work Order ID:

108837

Parent Item:

D3595-063-450

Parent Item Name:

Rubber Cushion

Start Date: 10/29/13

Required Date: 10/29/13

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP Rev:A New Issue 07-08-07 JLM Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
MNEO80S.125 NEOPRENE SHEET 0.125	5	Purchased	No			100	sf	228.5044	0.0196	0.618948		14.01.07
				Location		Loc Qty	Lo	c Code				

 Loc Oty

 MAT052
 228.5044

 115916
 131.1044

 94539
 97.4

94539-> 1.00

DQA:		_ Date:			MORK ORDER MON							
QA Closed:	•	Date:			WORK ORDER NON-	-C(JNFOI	RIVIAINCE / U		Work Order	update only	AEROSPACE
Manle Ouds			****		DISPOSITION				AGAINST [DEPARTMEN	IT/PROCESS	
Work Orde	: I .				Dowork .	1		Skid-tube	Crosstube	_	Water Jet	
Part N	lo				Rework Scrap			Machining	Small Fab	\dashv 。	rod. Eng. Coor.	Engineering Quality
raiti	····				Use-as-is		•	noforming	Finishing		tore/Packaging	Other
NCR N	No.				Suspected Unapproved		l IIICIII	Large Fab	Composite	- 1100/3	Supplier	
						2					2441.1	
Root				Desc	ription of work order update	Į į	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design												
Doc/Data					·							
Equip/Tooling												
Handling/Pre												
Material			ŀ									
Operator												
Offset/Setup												
Process												· .
Supplier					•							
Training						1						
Transport												
Unapproved			<u> </u>			<u> </u>						
						FA	ULT CA	regory				
Landii	ng Gear				General	_	1		Г		г	
	Bending			-	Bend	<u> </u>	1	rogram	-	— ;	imensions	Pressure/Forced
	—	lot Conce	ntric	-	BOM/Route	_	Grain		}-	_	er tolerance	Set-up
	Cracks			-	Broken/Damage/Defect	_	Hardwa			Part Incor	 	Temperature/Cure
		ink/Ripple	e/Wave	-	Burrs		1 '	ion Incomplete/Ui	· ` -	Part Lost/	· · ·	Weld
	Cuffs			-	Contamination	-	4	ions Incomplete/U	Unclear	Part Move	L	Wrong Stock Pulled
	Crushing			-	Countersink	\vdash	1	ned/off center	-	Positione		
!	Heat Tre		T I	-	Cut Too Short	\vdash	Mislabe		L	Power Lo	ss/Surge [Other
	⊢ ⊣ '	on Strip in	Tube	-	Drawing	<u> </u>	Misread					
	Marks/C			-	Drill Holes	\vdash	Off-set					
		Sequence wist in Tul		\vdash	Finish Fit/Function	-	4	Calibration Sequence			·· ······	
	i ivvave/l\	vvistili tUl	uc		TERVE UNICHOUS	1	TOUL OF:	DEGUETICE				

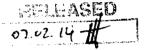
H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	108837
Description: Rubber Cushion	Part Number:	D3595-063-450
Inspection Dwg: D3595 Rev: A		Page 1 of 1

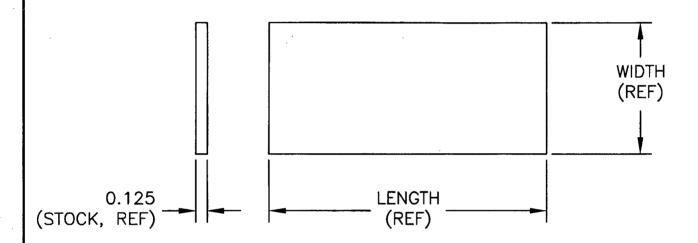
spection Dwg: L	03595 Rev : A	\				Pa	ge 1 of 1
	FIRST A	ARTICLE IN	SPECTIO	ON CHE	CKLIST	·	
	X	First Artic	le	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
0.63	+/-0.030	.63	_		~	UKm-c	 5
4.50	+/-0.030	4.50	_		V		
0.125	+/-0.010	-778	_		V		
			DAS				
easured by:		Audited by:	27 9-89,		Prototype A	pproval:	N/A
	.01.07	Date:	14/1/-	7		Date:	N/A
ev Date C	Change New Issue				Revis	sed by	Approve



DESIGN PH	DRAWN BY	DART AEROSF HAWKESBURY, ONTAF	· · · · · · · · · · · · · · · · · · ·
CHECKED ://	APPROVED //	DRAWING NO.	REV. A
	1	1 D3595	SHEET 1 OF 1
DATE		TITLE	SCALE
07.02.07		RUBBER CUSHION	NTS
Α	07.02.07	NEW ISSUE	



SPECIFICATION CONTROL DRAWING



SPECIFICATION: D3595-XXX-YYY RUBBER CUSHION

| 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c | 13/0-3c |

EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

NOTES

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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